

Date: Tuesday, 2/26/2008 8:02:51 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CABIN FLOOR PROTECTOR
Job Number : 37646	
Estimate Number : 12662	
P.O. Number :	Part Number : D35752
This Issue : 2/26/2008 S.O. No. :	Drawing Number : D3575 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / 1 Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 37208	Material :
Written By :	Due Date : 3/10/2008 Qty: 2 Um: Each
Checked & Approved By : <u>JA 080226</u>	
Comment : Est Rev : A New Issue 07-01-22 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	F60029	ML EXS125F6002904	lexan grey
-----	--------	-------------------	------------



Comment: Qty.: 10.6660 sf(s)/Unit Total : 21.3320 sf(s)

F60029 lexan sheet

Batch: 103106 IB 8-3-3

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3575

Dwg Rev: A IB 8-3-3

Prog Rev: A

2-Deburr if necessary



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-3-3

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

508/03/04 (Y2)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

X2

Deburr if necessary.

**D3575-2**

**508 #**

**37646**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 08/03/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:02:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 37646

Part Number: D35752

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 08/03/06 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock  
Location: *Handwritten:* 37628, 37646, 37647

*Handwritten:* 5/13/06 50

*Handwritten:* (2x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*Handwritten:* (2)

Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten:* 08/03/06

Job Completion



*Handwritten:* mi 2008/3/06

*Handwritten:* (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

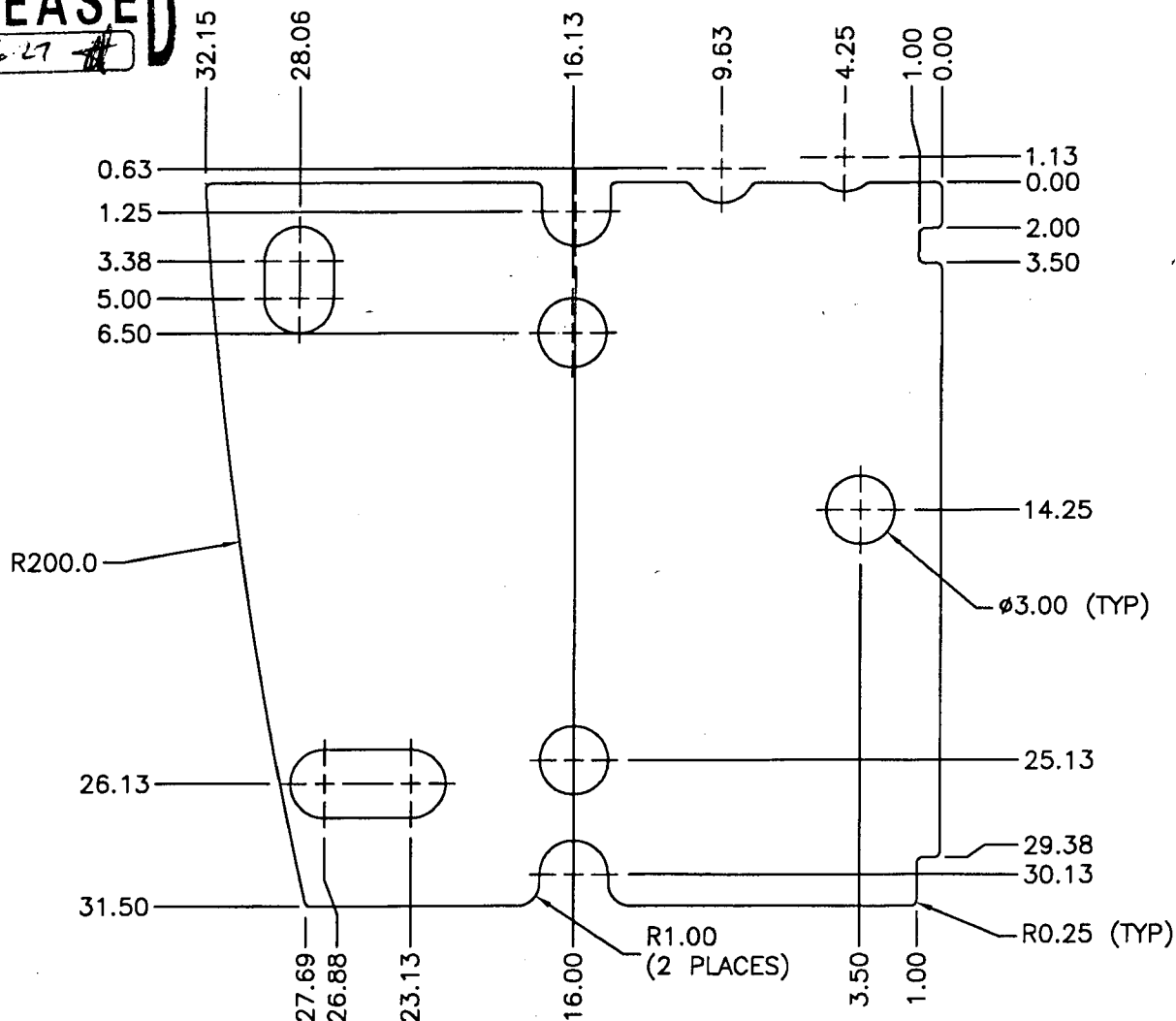
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>#</i>	DRAWING NO. D3575	REV. A SHEET 1 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8
A	07.06.08	NEW ISSUE	

**RELEASED**  
07.06.08 *#*

**D3575-1 CABIN FLOOR PROTECTOR (SHOWN)**  
**D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)**

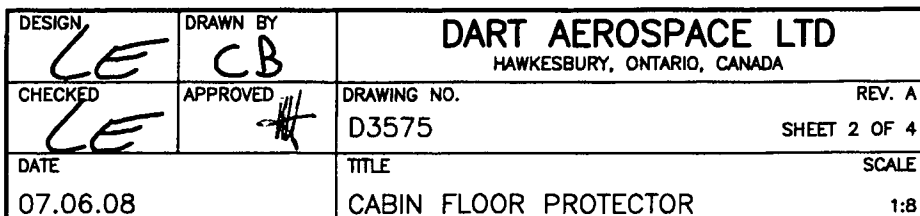
**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125" THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

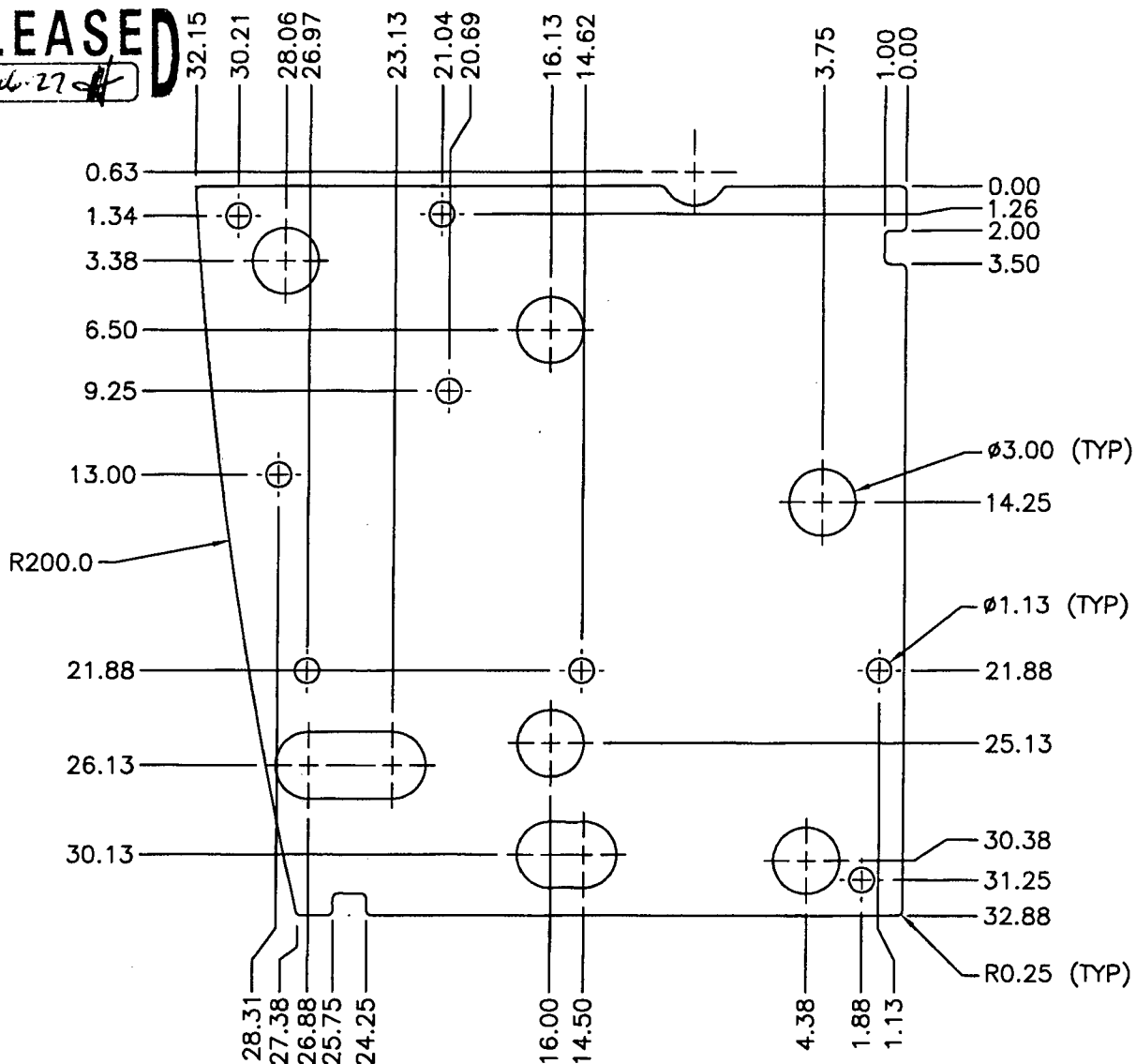
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WORK ORDER  
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RELEASED  
07-16-27



### D3575-3 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK  
TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER  
ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967
- UNCONTROLLED  
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WORK ORDER  
37646

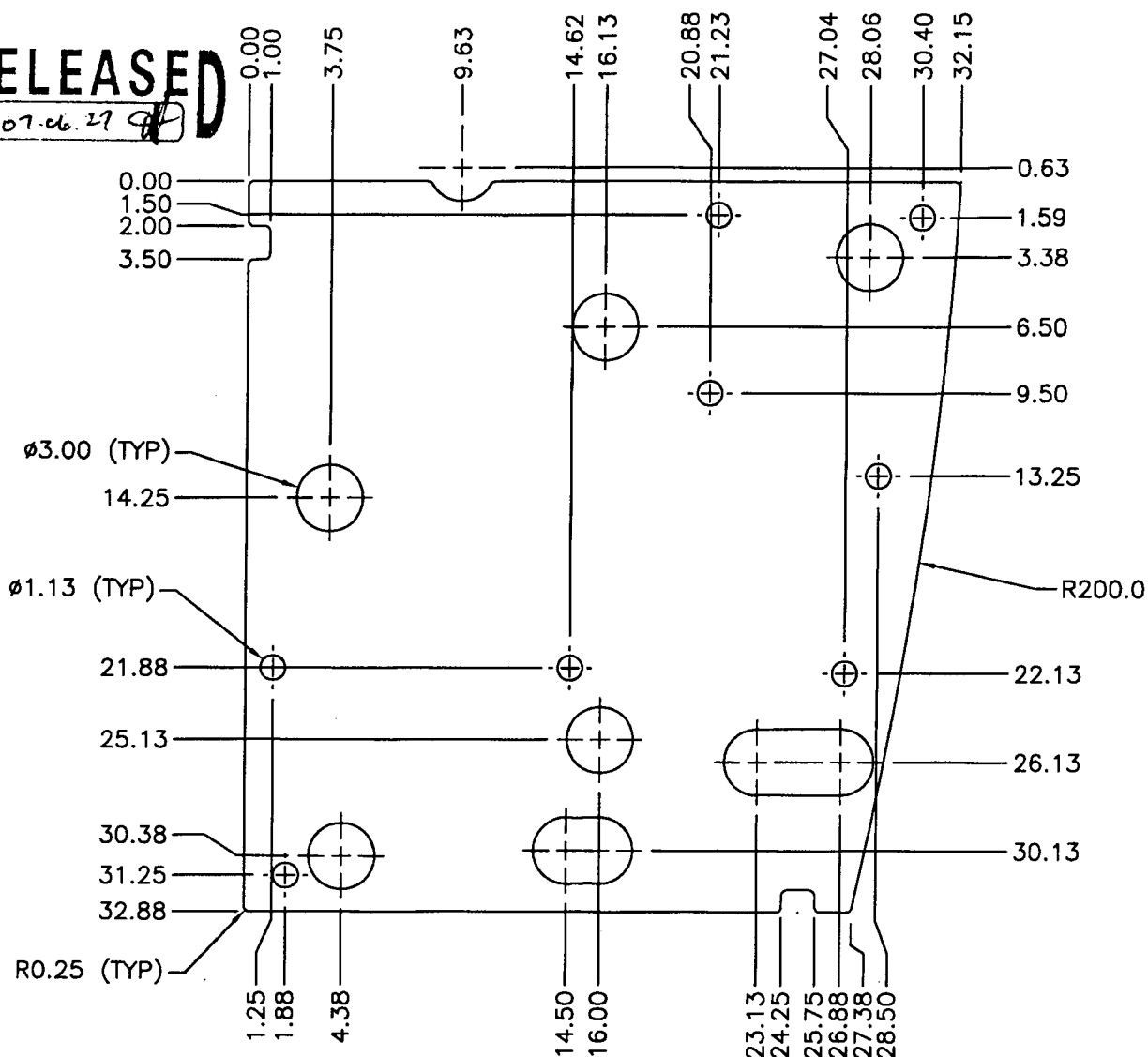
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**DART**

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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3575	REV. A SHEET 3 OF 4
DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:8

**RELEASED**  
07.06.27**D3575-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125" THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

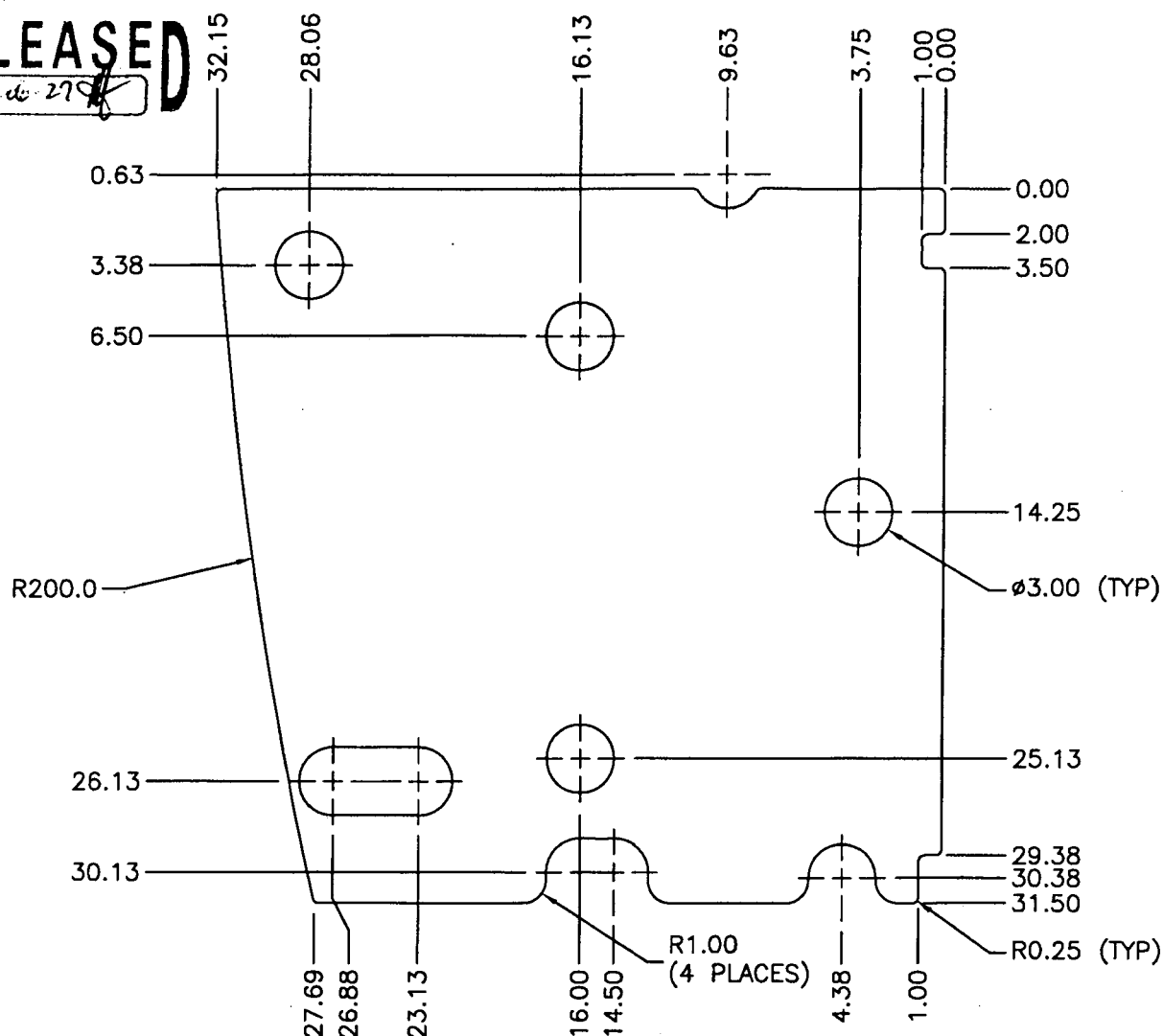
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CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3575	REV. A SHEET 4 OF 4
DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:8

**RELEASED**  
07-06-27

**D3575-5 CABIN FLOOR PROTECTOR (SHOWN)**  
**D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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DART AEROSPACE LTD		Work Order: 31646
Description: CABIN FLOOR PROTECTOR		Part Number: D3575-2
Inspection Dwg: D3575-2 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.00	+ .006 - .001	3.00				
1.25	+/- .030	1.25				
3.38	+/- .030	3.38				
5.00	+/- .030	5.00				
6.50	+/- .030	6.50				
26.13	+/- .030	26.13				
31.50	+/- .030	31.50				
2.00	+/- .030	2.00				
3.50	+/- .030	3.50				
14.25	+/- .030	14.25				
25.13	+/- .030	25.13				
29.38	+/- .030	29.38				
30.13	+/- .030	30.13				
1.00	+/- .030	1.00				
3.50	+/- .030	3.50				
16.00	+/- .030	16.00				
23.13	+/- .030	23.13				
26.88	+/- .030	26.88				
27.69	+/- .030	27.69				
4.25	+/- .030	4.25				
9.63	+/- .030	9.63				
16.13	+/- .030	16.13				
28.06	+/- .030	28.06				
32.15	+/- .030	32.15				

Measured by: EB	Audited by: J	Prototype Approval: M
Date: 8-3-3	Date: 08/08/04	Date: 10

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	